

Work Order ID 83590

Thursday, April 19, 2012 3:45:49 PM

83590

ASAP

Page 1

Item ID: D4099-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 4/19/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/23/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 12-04-20 Tooling:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4099

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

6061 .080

⑥

Ø

Jm / *h/h*
12-4-20

110

0.00

110QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

⑥

Ø

Jm / *h/h*
12-4-20

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/2/12/20

⑥

76

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83590

Thursday, April 19, 2012 3:45:49 PM

83590

Page 3

Item ID: D4099-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 4/19/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/23/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

⑥ 76 12-4-23

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

170

Powdercoat

Memo

Start Time: 10:20

Oven Temperature: 320°F

Finish Time: 10:50

0.00

Powder Coating

M 117338

6X 4 M-A 12/04/24

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

6 φ BL 12-4-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, April 19, 2012 3:45:49 PM

Page 1

Work Order ID: 83590
Parent Item: D4099-1
Parent Item Name: Bracket

Start Date: 4/19/2012

Required Date: 4/23/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A as per ECN10-573 DD 10.05.18 verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	558.1500	0.2627	1.6591579			
6061-T6 .080 Sheet													

Location

MAT021

Loc Qty

558.15

Loc Code

117285

2.15

119766

39.77

120096

312.83

120349

11.4

121193

192

120096.

Jan. wh
12-4-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

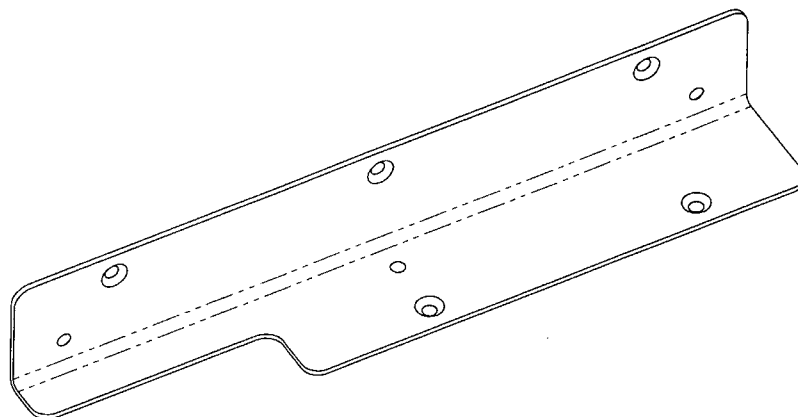
DART AEROSPACE LTD		Work Order: 83590
Description: Bracket		Part Number: 09099-1
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

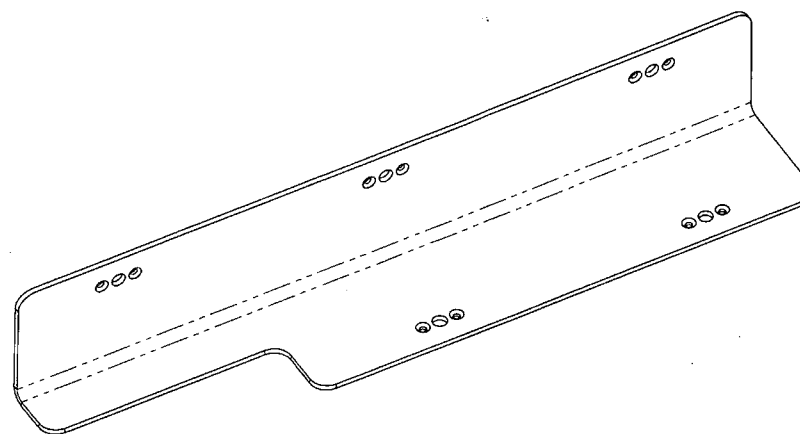
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.201	+0.005 -0.001	0.203	✓		vern	HB-02
4.000	± 0.030	4.002	✓		vern	HB-02
4.000	± 0.010	4.003	✓		vern	HB-02
1.500	± 0.010	1.496	✓		vern	HB-02
0.375	± 0.010	0.375	✓		vern	HB-02
2.689	± 0.010	2.682	✓		vern	HB-02
3.44	± 0.030	3.438	✓		vern	HB-02
0.750	± 0.010	0.750	✓		vern	HB-02
9.500	± 0.010	9.508	✓		vern	HB-02 Prod-W-3-02
7.50	± 0.030	7.506	✓		vern	HB-02
11.00	± 0.030	11.014	✓		vern	Prod-W-3-02
2.44	± 0.030	2.443	✓		vern	HB-02
2.219	± 0.010	2.220	✓		vern	HB-02
1.215	± 0.010	1.217	✓		vern	HB-02
R. 0.25	± 0.030	0.25	✓		RG	
0.080	± 0.010	0.077	✓		vern	HB-02

Measured by: Jm- <i>[signature]</i>	Audited by: S	Prototype Approval:		
Date: 12-4-20	Date: 12/4/20	Date:		
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4099-1 BRACKET



D4099-3 BRACKET

83590

RELEASED
2010-05-17

REV.	NEW ISSUE	DESCRIPTION	MB	10.05.05
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.05.05			

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. A
D4099	SHEET 1 OF 3
TITLE	SCALE
BRACKET	NTS

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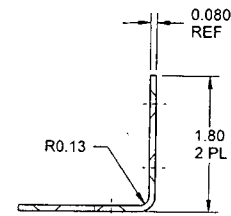
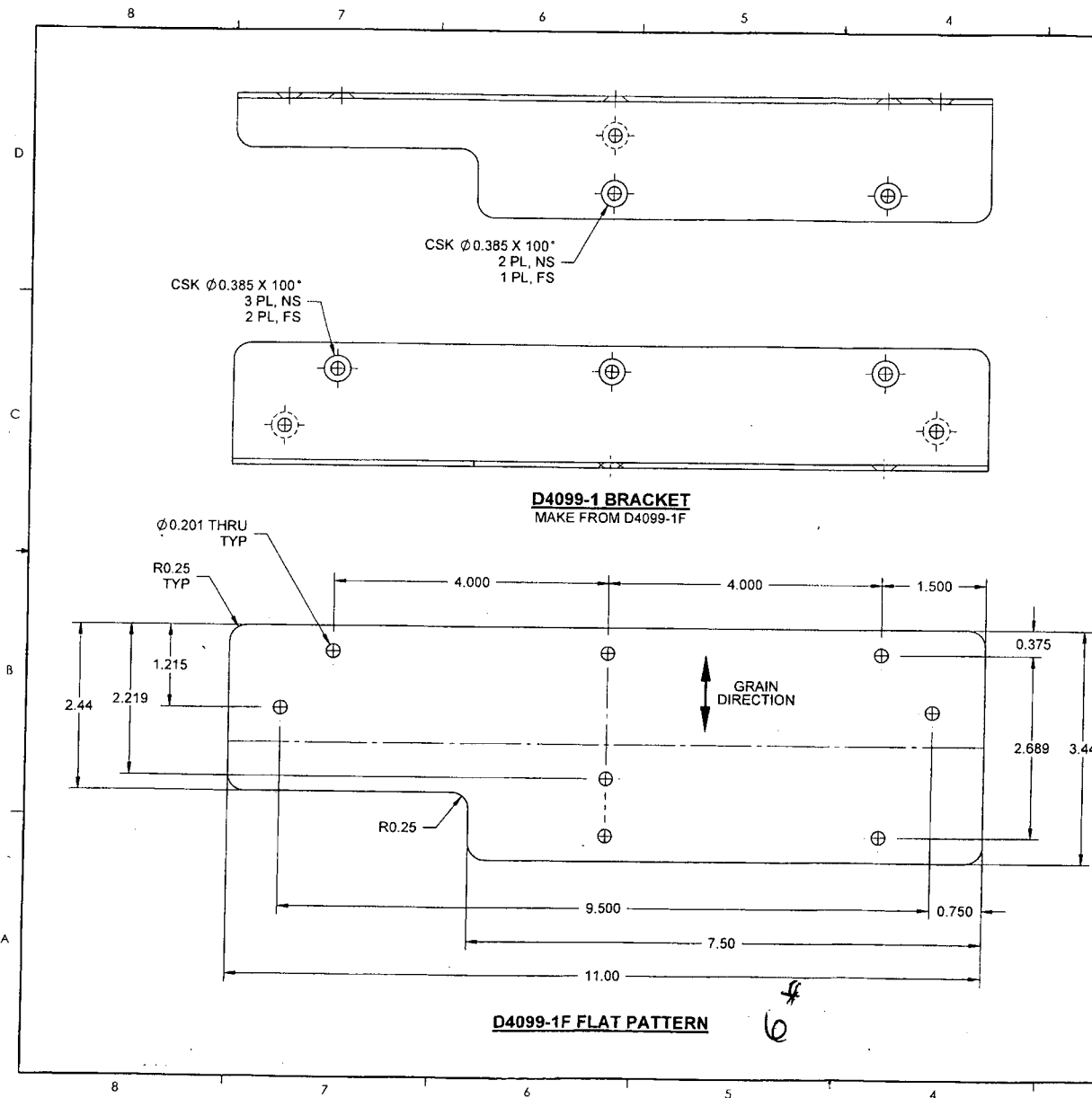
W/O:		WORK ORDER CHANGES					
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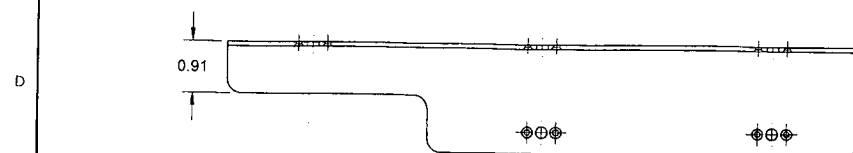
83596

RELEASED
2010-05-17

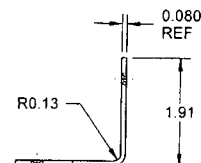
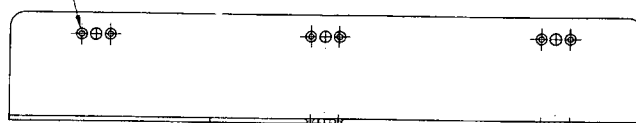
- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR
ASTM B209
REF. DART SPEC. M6061T6S 080
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART
QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.26 lbs

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. A
MFG. APPR.	1	D4099	SHEET 2 OF 3
APPROVED	1	TITLE	SCALE
DE APPR.	1	BRACKET	NTS
DATE	10.05.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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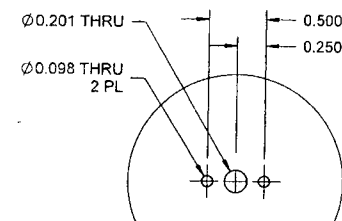
8 7 6 5 4 3 2 1



CSK $\phi 0.188 \times 100^\circ$
TYP



D4099-3 BRACKET
MAKE FROM D4099-3F

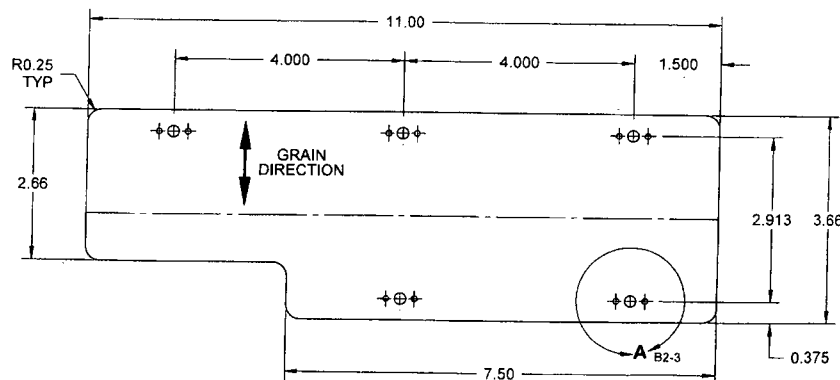


DETAIL A
SCALE 2X, 5 PL

#8359 U
RELEASED
2010-05-17
MP

NOTES:

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REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs



D4099-3F FLAT PATTERN

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4099 REV. A
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE	10.05.05	

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8 7 6 5 4 3 2 1